

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009125**Date Inspected:** 14-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen fu you**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

**SEGEMENT**

FCAW welding of weld joint 3F-009 located on PCMK SSD15-PP61 of 8AE welder is identified as 066683. ZPMC QC is identified as Mr. Wang xian pin . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133

SMAW welding of repair weld joint 2G-004 located on PCMK SSD19-PP054 of 7CE welder is identified as 0543661.ZPMC QC is identified as Mr. Guo xing hui . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2F(2G)-Repair and WR6912.

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FCAW welding of weld joint 3G-135 located on PCMK SSD13-PP91 of 10BW welder is identified as 202122. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW welding of weld joint 4G-131 located on PCMK SSD13-PP84 of 9EW welder is identified as 067610. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2114-Tc-U4b-FCM-1.

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## WELDING INSPECTION REPORT

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SAW welding of weld joint 1G-006 located on PCMK SEG055\* of 9DW welder is identified as 045265.ZPMC QC is identified as Mr.Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

Witnessed ongoing ZPMC UT of Deck panel splice weld PCMK SEG051\*-004 of 9BW, three UT technicians working on that weld joint.

Witnessed ZPMC MT of distortion deck panel weld joint cut splice PCMK SEG057\*-005 carried out as per WR7456.

It is observed that the 3G CJP FCAW Weld joint fit up of SSD12-PP82-131, not as per approved WPS. (WPS-B-T-2233-B-U2-F). improper Bevel angel and grinding cut mark on that joint. Informed to ZPMC QC Mr.Li ming yang.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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